



Dart Aerospace Ltd.
1270 Aberdeen St
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K6A 1K7
Canada

Tel (613) 632-5200
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D5127-1

Job Sheet 191813



Part No: D5127-1

Job Qty: 12 pcs

Part Name: Shim, Large



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/8/19

Job Tracking No:

Due Date: 3/11/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 14-07-30 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	12 pcs		3/11/19	0.00	0.00	Bandsaw - 1		anme 19/03/19
110	HAAS 4 Axis - B4B	12 pcs		3/11/19	0.00	3.82	HAAS - 1 - B4B		anme 19/03/19
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	12 pcs		3/11/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		anme 19/03/19
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		



Container No: S160864



Part: D5127-1

Job No: 191813

Serial No/Batch: S160864

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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www.dartaerospace.com

Date: 03/09/19

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130 QC 8	12 pcs	3/11/19	0.00 0.00	QC 2 - 57					
				QC 2 - 62					
				QC 2 - 63					
				QC 2 - 8					
				QC 2 - 66					
				QC 2 - 64					
				QC 2 - 65					
				QC 8 - 12					
				QC 8 - 14					
				QC 8 - 17					
				QC 8 - 20					
				QC 8 - 25					
				QC 8 - 3					
				QC 8 - 32					
				QC 8 - 33					
				QC 8 - 35					
				QC 8 - 39					
				QC 8 - 4					
				QC 8 - 44					
				QC 8 - 45					
				QC 8 - 49					
				QC 8 - 58					
				QC 8 - 8	D.R 19-03-10				
QC 8 - 9									
QC 8 - 68									
QC 8 - 67									
QC 8 - 1 (A)									
QC 8 - 47									
QC 8 - 40									
140 Handfinish - 1-1 Chemical-B4B	12 pcs	3/11/19	0.00 0.38	Handfinish - 1 - 1 - B4B					
				Handfinish - 1 - 2 - B4B					
				Handfinish - 1 - 3 - B4B					
				Handfinish - 1 - 4 - B4B					
				Handfinish - 1 - 5 - B4B					
				Handfinish - 1 - 6 - B4B					
				Handfinish - 1 - 7 - B4B					
				Handfinish - 1 - 8 - B4B					
				Handfinish - 1 - 9 - B4B					
				Handfinish - 1 - 10 - B4B	D.R 19/03/12				
				Handfinish - 1 - 11 - B4B					
				Handfinish - 1 - 12 - B4B					
				Handfinish - 1 - 13 - B4B					
				Handfinish - 1 - 14 - B4B					
				Handfinish - 1 - 15 - B4B					
				Handfinish - 1 - 16 - B4B					
				Handfinish - 1 - 17 -					
								Plex 3/8/19 2:29 PM Dart.lajeunesse.marie	

https://www.plexonline.com/3d3a02a0-c353-44de-928a-f503f6895e5c/Plexus_Control/Report_View/Viewer_2.asp?URL=../Part/Job_Sheet.asp&Report=Tru... 3/5

				QC 3 - 9	
				QC 3 - 40	
170 Packaging 3-1 - Stock - B4B	12 pcs	3/11/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	574388
				Packaging 3 - 5 - B4B	MAR 12 2019
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	12 pcs	3/11/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	MAR 13 2019 70
				QC 21 - SA - 53	9-89

Part Op 100 - Cut blank:2.250" LONG

Descriptions: 110 - (HAAS CNC Vertical Machine), 1- Machine as per Folio FB326 and Dwg FOLIO REV: _____ DWG

REV: _____ - Deburr

120 - QC2- Inspect parts off machine FAI/FAIB

130 - QC8- Inspect parts - second check

140 - Chemical Conversion Coat per QSI005 4.1

141 - QC7-Inspect Chemical Conversion Coat

150 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: 9:25 OVEN TEMPERATURE: 320°

FINISH TIME: 9:55 11/38997

160 - QC3- Inspect Part Finish

170 - Identify as per dwg & Stock Location: _____

180 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.250X02.000	6061-T6 Bar .250 X 2.00	2.2500 ft (.1875 ea)	100-Bandsaw - 1	F 123279

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B0.250X02.000	2	154	0
Part Specifications				
Spec No	Description	Target/Tolerance	Limits	Type
1	Shim, Large	0.064Inches $\pm$ 0.010	0.074 0.054	063
2	Shim, Large	0.128Inches $\pm$ 0.010	0.138 0.118	130
3	Shim, Large	0.340Inches $\pm$ 0.030	0.370 0.310	338
4	Shim, Large	2.000Inches $\pm$ 0.010	2.010 1.990	2.00
5	Shim, Large	1.320Inches $\pm$ 0.010	1.330 1.310	1.324
6	Shim, Large	0.340Inches $\pm$ 0.030	0.370 0.310	338
7	Shim, Large	1.110Inches $\pm$ 0.010	1.120 1.100	1.115
8	Shim, Large	1.790Inches $\pm$ 0.030	1.820 1.760	1.790
9	Shim, Large	0.180Inches + 0.005 - 0.001	0.185 0.179	Diameter 184

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